

Work Order ID 74942

October 13, 2011 1:06:33 PM

74942

Page 1

Item ID: D407-667-105TRN

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Turning Detail

Start Date: 10/13/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/11/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: ML J

Date: 11/10/13 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D407-667-145

Rev C

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8673 on both ends as per Folio FA249

2-Turn first side as per Folio FA249

3-Blend transition lines only, **do not sand-whole tube**

FOLIO REV: AA

DWG REV: C

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

110

QC1- Inspect dimensions to dimension sheet

0.00

110

QC

Memo

0.00

Quality Control

1 0

MM.L 11/11/28

1 0

MM.L 11/11/28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120

0.00

120

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA249

2-Blend transition lines only, **do not sand whole tube**:

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

FOLIO REV: AADWG REV: ET

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-145
inside of Cuff(Do not engrave on outside of tube)

M.M.L 11/11/28

130

QC1- Inspect dimensions to dimension sheet

0.00

130

QC

Memo

0.00

Quality Control

M.M.L 11/11/28

M.M.L 11/11/28

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October 13, 2011 1:06:33 PM

74942

Item ID: D407-667-105TRN

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Crosstube Turning Detail

Stop ***NS2***

Start Date: 10/13/11 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 11/11/11 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____ **SPC (Y/N):** _____ **Date:** _____

SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

140 QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

150 Crosstubes Chemical Conversion

0.00

150

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

160 QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

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NOTE: Date & initial all entries

Work Order ID 74942***74942***

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October 13, 2011 1:06:33 PM

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Cust Item ID:

Required Date: 11/11/11 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170 | | 0.00 | | | | | | | |
| *170* | Packaging | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and stock in Kanban rackLocation: <u>LG</u> | | | | | | | | |
| 180 | | | | | | | | | |
| *180* | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

① SAP 11-12-0111/12/5
ME
11-12-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

October 13, 2011 1:06:37 PM

Page 1

Work Order ID: 74942

74942

Parent Item: D407-667-105TRN

D407-667-105TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 10/13/11

Required Date: 11/11/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:a08.02.28 new issueEC
IPP Rev B 08.04.02 Removed polish EC verified by: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D6010-115 | | Manufactured | No | | | 110 | Each | 25.0000 | 1 | 1 | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|

D6010-115

Crosstube Material

Location

Loc Qty

Loc Code

LG

25

38343

25

1 mmd 11/11/28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

74942

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|--|-------------------------------------|
| DART AEROSPACE LTD | Work Order: 74809 |
| Description: Crosstube Assembly | Part Number: D407-667-145 |
| Inspection Dwg: D407-667-145 Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| | Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------|------------------------------------|---------------|------------------|--------|--------|----------------------|----------|
| SIDE A | 2.240 | +0.005/-0.000 | 2.247 | ✓ | | vern | CNC-OK |
| | 1.865 | +0.005/-0.000 | 1.869 | ✓ | | " | |
| | 1.878 | +0.005/-0.000 | 1.880 | ✓ | | " | |
| | 1.970 | +0.005/-0.000 | 1.975 | ✓ | | " | |
| | 2.030 | +0.005/-0.000 | 2.034 | ✓ | | " | |
| | 2.165 | +0.005/-0.000 | 2.168 | ✓ | | " | |
| | | | | | | | |
| | 0.125 | +/-0.010 | .125 | ✓ | | vern | CNC-OK |
| | R0.063 | +/-0.010 | .063 | ✓ | | Rb | |
| | R0.500 | +/-0.010 | .500 | ✓ | | " | |
| | R0.063 | +/-0.010 | .063 | ✓ | | " | |
| | 4.438 | +/-0.030 | 4.440 | ✓ | | vern | CNC-OK |
| | | | | | | | |
| | | | | | | | |
| SIDE B | 2.240 | +0.005/-0.000 | 2.241 | ✓ | | vern | CNC-OK |
| | 1.865 | +0.005/-0.000 | 1.870 | ✓ | | " | |
| | 1.878 | +0.005/-0.000 | 1.882 | ✓ | | " | |
| | 1.970 | +0.005/-0.000 | 1.974 | ✓ | | " | |
| | 2.030 | +0.005/-0.000 | 2.031 | ✓ | | " | |
| | 2.165 | +0.005/-0.000 | 2.167 | ✓ | | " | |
| | | | | | | | |
| | 0.125 | +/-0.010 | .125 | ✓ | | vern | CNC-OK |
| | R0.063 | +/-0.010 | .063 | ✓ | | Rb | |
| | R0.500 | +/-0.010 | .500 | ✓ | | " | |
| | R0.063 | +/-0.010 | .063 | ✓ | | " | |
| | 4.438 | +/-0.030 | 4.440 | ✓ | | vern | CNC-OK |
| | 113.20 | +/-0.020 | 113.195 | ✓ | | type | CNC-OK |
| | | | | | | | |
| | | | | | | | |

| | | |
|---------------------------------|------------------------------|------------------------------|
| Measured by: <i>mm.l</i> | Audited by: <i>DP</i> | Preliminary Approval: |
| Date: 11/11/28 | Date: 11-11-30 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------------|------------|----------|
| A | 04.04.21 | New Issue (P/O D407-667-105) | KJ/RF | |
| B | 06.03.09 | Dwg Rev updated | KJ/JLM | |
| C | 09.06.11 | Dwg Rev updated | KJ | |
| D | 11.06.21 | Tolerance revised for 4.438 dimension | KJ | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| Item | Qty -145 | Part Number | Description |
|------|-------------|-------------------|--|
| 1 | X | D407-667-145 | CROSSTUBE ASSEMBLY (407 HIGH FWD) |
| 2 | 1 | D6010-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2891-1 | SUPPORT |
| 6 | 4 | D3595-063-395 | RUBBER CUSHION |
| 7 | 4 | MS21920-20 | CLAMP (OR MS21920-21) |
| 8 | 14 | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. ~~4481009~~ M.L.3

74942 11/10/12

DEO ATTACHED

ECW #11-615
11.07.26

UNDER REVIEW

RELEASED
08/11/12 MLD

| | | | |
|------------|---|--|--------------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 02.05.08 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | DRAWING NO. | REV. C |
| CHECKED | RF | D407-667-145 | SHEET 1 OF 4 |
| MFG. APPR. | RF | TITLE | SCALE |
| APPROVED | RF | CROSSTUBE ASSY (407 HIGH FWD) | NTS |
| DE APPR. | RF | COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 08.11.06 | | |

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

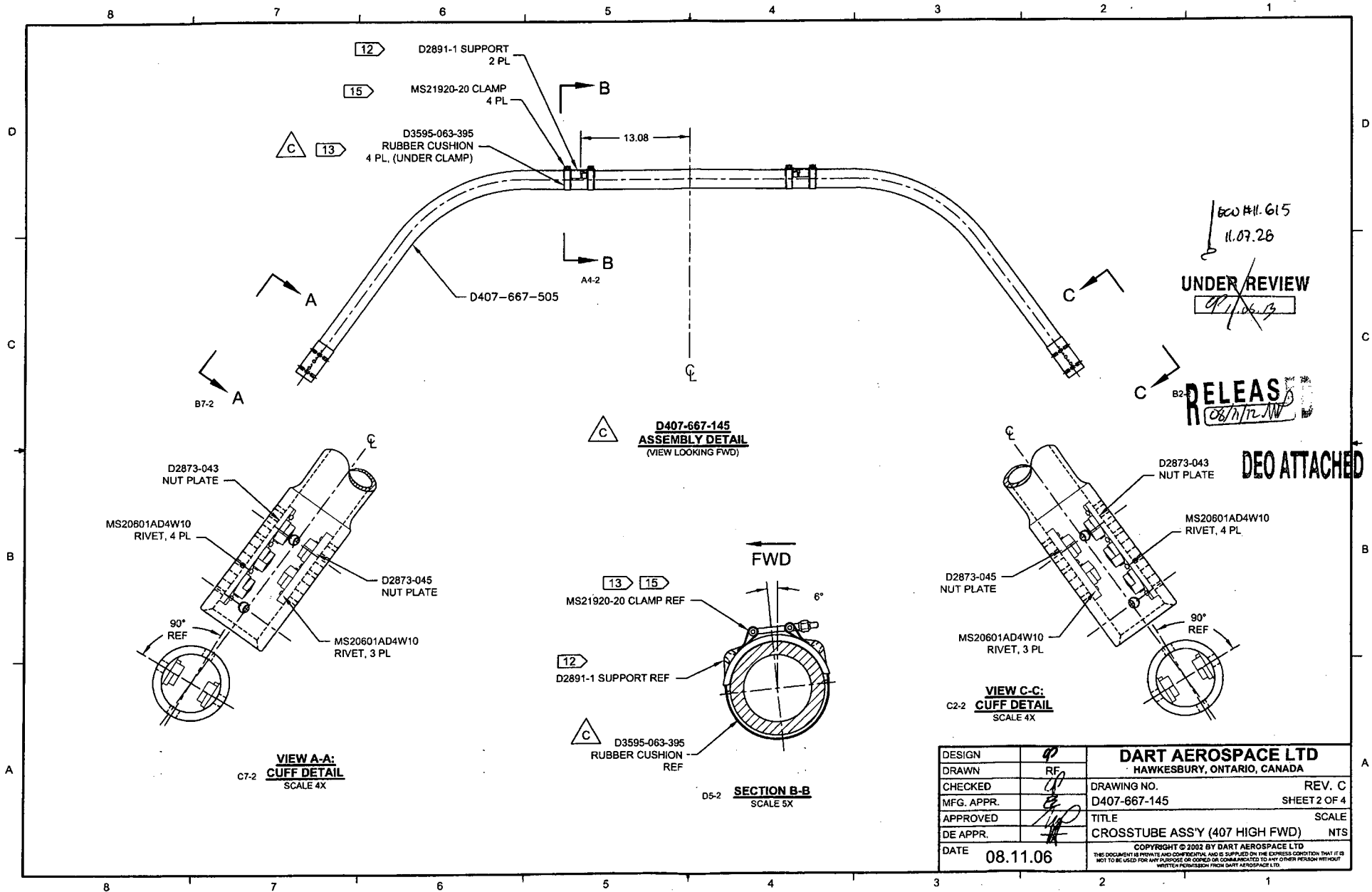
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

74942

[Handwritten signature]



| | | | |
|--|----------|--|--------------|
| DESIGN | 47 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 47 | DRAWING NO. | REV. C |
| MFG. APPR. | 47 | D407-667-145 | SHEET 2 OF 4 |
| APPROVED | 47 | TITLE | SCALE |
| DE APPR. | 47 | CROSSTUBE ASS'Y (407 HIGH FWD) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2002 BY DART AEROSPACE LTD | |
| THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

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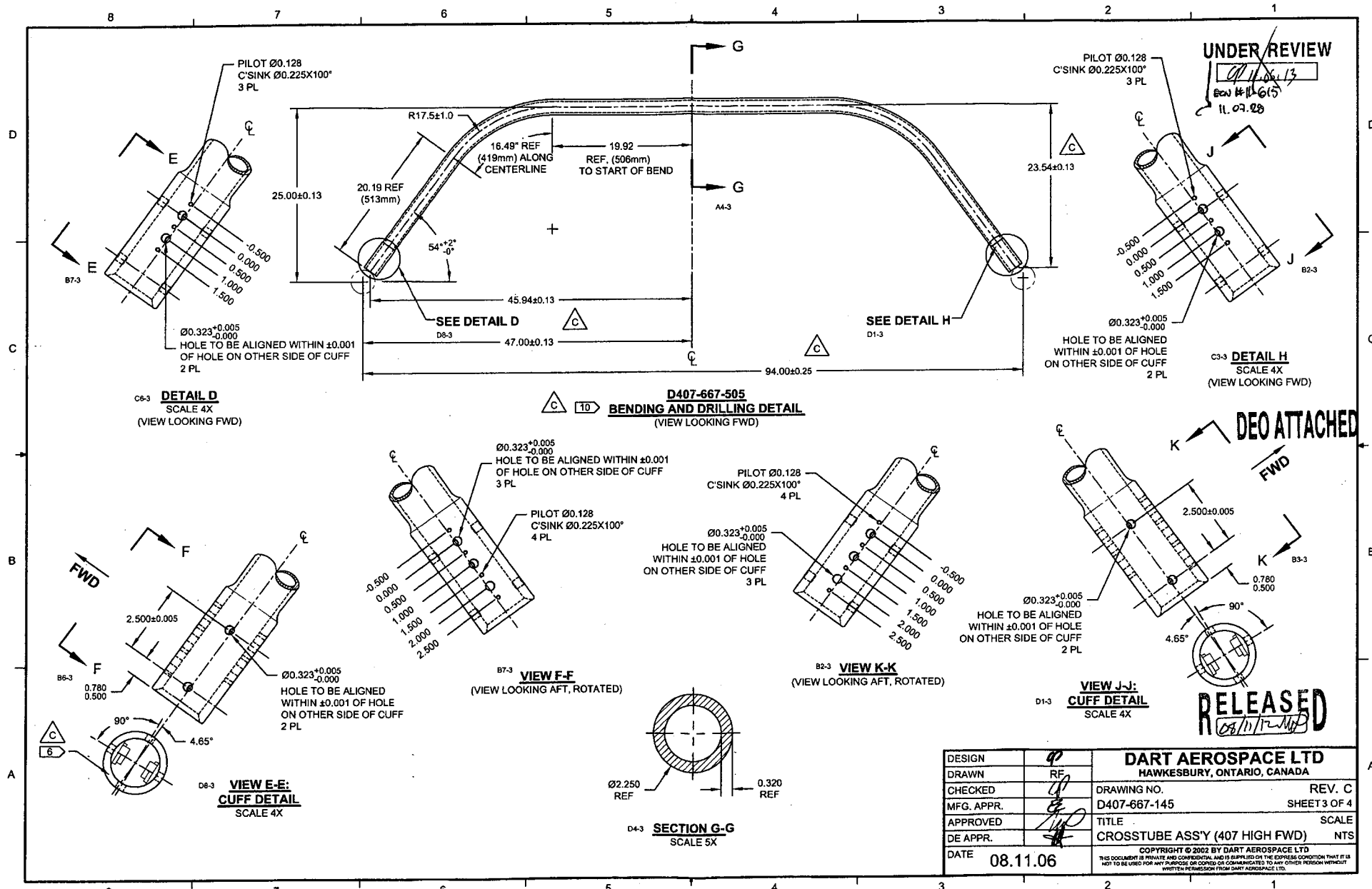
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

74942
 200000



UNDER REVIEW
 11.07.28

DETAIL H
 SCALE 4X
 (VIEW LOOKING FWD)

DEO ATTACHED
 FWD

RELEASED
 08/11/06

| | | | |
|------------|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. C |
| MFG. APPR. | RF | D407-667-145 | SHEET 3 OF 4 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | CROSSTUBE ASSY (407 HIGH FWD) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

74942

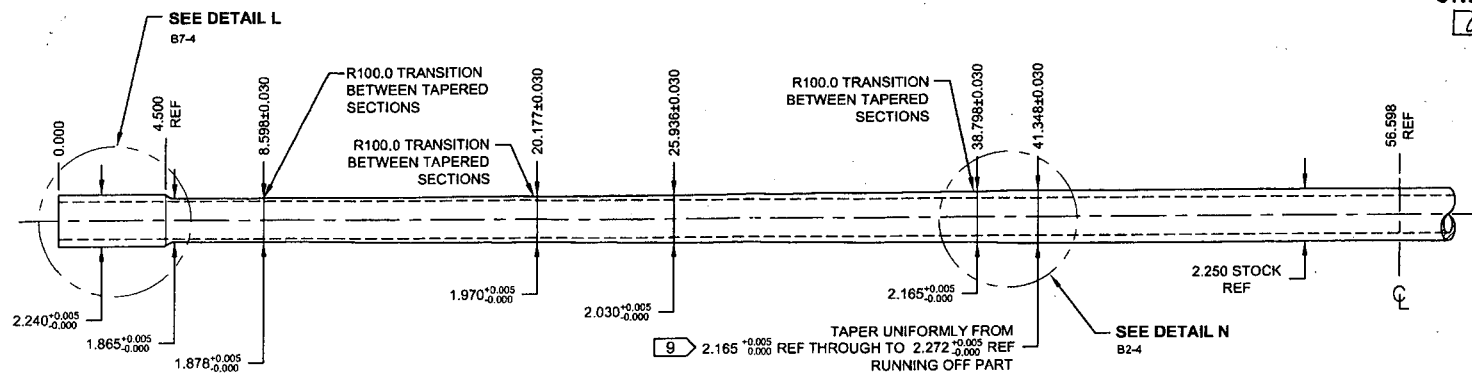
2009

UNDER REVIEW

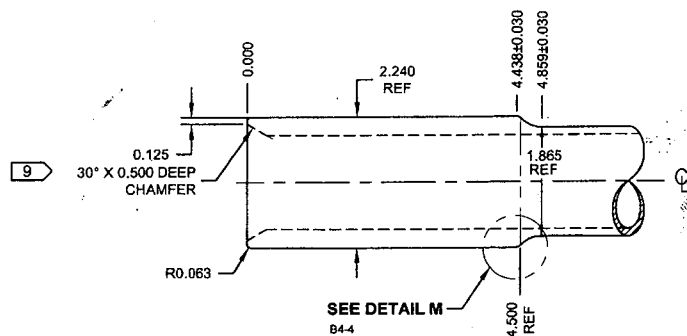
08/11/06

08/11/06

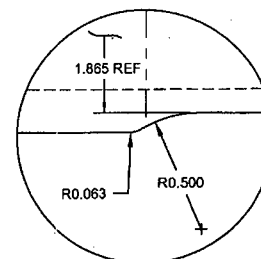
1.07.26



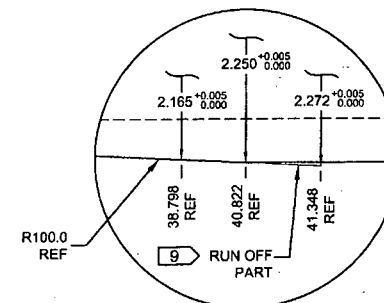
C TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
D7-4 NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
D6-4 NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
C3-4 NOT TO SCALE

DEO ATTACHED

RELEASED
08/11/06

| | | | |
|------------|----------|--|--------------|
| DESIGN | 9 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 9 | DRAWING NO. | REV. C |
| MFG. APPR. | 9 | D407-667-145 | SHEET 4 OF 4 |
| APPROVED | 9 | TITLE | SCALE |
| DE APPR. | 9 | CROSSTUBE ASS'Y (407 HIGH FWD) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

74942

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|-----------------------------|---|-------------------|---|------------------|--------------------------------|---------------------------|--------------|
| DRAWING NO. D407-667-145 | TITLE CROSSTUBE ASS'Y (407 HIGH FWD) | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D407-667-145-C-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN 97 | CHECKED 155 | MFG. APPR. 155 | APPROVED WD | DE APPR. 11 | | | |
| DATE 11.07.15 | DATE 11.07.22 | DATE 11.07.22 | DATE 11/07/22 | DATE 11.07.21 | | | |

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

| Item | Qty -145 | Part Number | Description |
|------|-------------|-----------------|-------------------------------|
| 9 | A/R | PROSEAL 890 B-2 | SEALANT, AMS-S-8802 CLASS B-2 |

WAS:

| | | | |
|---|-----|----------------|---|
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |
|---|-----|----------------|---|

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRABE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
WD

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries